

On-Oil Conditions	Test Case 1	Test Case 2	Test Case 3	Test Case 4
Temperature (°F)	835	813	835	818
Pressure (Psig)	300	300	300	300
WHSV (#/#/hr)	4.2	3	3	3
H ₂ :Feed Toluene Ratio (moles)	0.5:1	0.5:1	2:1	2:1
Hydrocarbon Partial Pressure (Psia)	196.1	196.1	93.4	93.4

On-Oil Catalyst Performance	Test Case 1	Test Case 2	Test Case 3	Test Case 4
Feed(100% Toluene) Conversion(wt.%)	31.0	30.2	28.2	25.0
Paraxylene Selectivity (PX/[PX+MX+OX]X100)	94.6	94.0	95.6	95.9
Benzene Yield (wt.%)	14.0	13.4	12.7	10.9
Xylene Yield (wt.%)	14.7	14.8	12.8	11.9
C ₅ - Yield (wt.%)	0.9	0.8	1.7	1.3
C ₉ ⁺ Yield (wt.%)	0.9	0.8	0.6	0.5

5 In Example 4, the H₂:oil ratio was lower during selectivation to reduce
 selectivation time from the 340 hours shown in Example 2. Cases 1
 and 2 demonstrate the very high xylenes production that can be
 achieved with the zeolite-bound catalyst at very reasonable
 temperatures and low hydrogen:oil ratios. Case 4 shows how an ultra-
 high selectivity of 95.9% can be achieved at a reasonable conversion
 10 and temperature.

Example 5

5 A zeolite bound zeolite catalyst having substantially the same composition as the catalyst described in Example 1 was evaluated for its ability to crack a light cat naphtha feed.

10 The test was carried out by first steaming the zeolite bound zeolite catalyst at 704°C for 16 hours for the purpose of aging the catalyst. Next, the naphtha feed was passed over the zeolite bound zeolite catalyst at 650°C, 1.9 hr⁻¹ WHSV, and at a 0.85 steam to hydrocarbon ratio. The tests was repeated except that the catalyst comprised MFI bound with 60% by weight of a binder (based on the weight of the catalyst) which comprised silica and alumina.

15 The results of the tests are shown in Table I below:

Table I

Catalyst	Conventional MFI	Zeolite-Bound MFI
Conversion	95.9	92.4
Key Product Yields, Wt%		
Ethylene	26.9	31.8
Propylene	23.2	30.3
Butylenes	7.0	6.8
Aromatics	21.1	12.2
Light Saturates	17.8	11.4
Methane	6.9	7.3

20 The results of these tests show that yields of ethylene and propylene were significantly increased and the selectivity to undesirable light saturates and aromatics was significantly reduced using the zeolite bound zeolite as a cracking catalyst.

1. A process for converting hydrocarbons comprising contacting a hydrocarbon feedstream under hydrocarbon conversion conditions with a zeolite bound zeolite catalyst comprising:
 - (a) first particles of a first zeolite; and,
 - (b) a binder comprising second particles of a second zeolite having an average particle size less than said first particles.
2. The process recited in claim 1, wherein said first particles of said first zeolite have an average particle size greater than 0.1 micron.
3. The process recited in claims 1 or 2, wherein the hydrocarbon conversion is selected from the group consisting of cracking of hydrocarbons, isomerization of alkyl aromatics, disproportionation of toluene, transalkylation of aromatics, alkylation of aromatics, reforming of naphtha to aromatics, and conversion of paraffins and/or olefins to aromatics.
4. The process of claims 1 to 3, wherein said hydrocarbon conversion is carried out at conditions comprising a temperature of from 100°C to about 760°C, a pressure of 0.1 atmosphere to 100 atmospheres, a weight hourly space velocity of from about 0.08 hr⁻¹ to about 200 hr⁻¹.
5. The process recited in claims 1 to 4, wherein said second zeolite is selected from the group consisting of a large pore zeolite, a medium pore zeolite, and mixtures thereof.
6. The process recited in claims 1 to 5, wherein said first zeolite is selected from the group consisting of a large pore zeolite, a medium pore zeolite, and mixtures thereof.

7. The process recited in claims 1 to 6, wherein said second zeolite particles have an acidity either higher or lower than said first zeolite particles.
- 5 8. The process recited in claims 1 to 7, wherein said first and second zeolites are selected from the group consisting of L, X, Y, offretite, omega, mordenite, MAZ, MEI, FAO, EMT, ZSM-3, ZSM-4, ZSM-18, ZSM-20, MFI, MEL, MTW, MTT, FER, EUO, HEV, TON, zeolite beta, ZSM-34, ZSM-38, ZSM-48,
10 gallosilicates, and titanosilicates.
9. The process recited in claims 1 to 8, wherein said second zeolite is silicalite.
- 15 10. The process recited in claims 1 to 9, wherein at least a portion of said first particles of said first zeolite have adhered structurally to these surfaces said second particles of said second zeolite.
- 20 11. The process recited in claims 1 to 10, wherein said binder contains less than 10% by weight of non-zeolitic binder based on weight of said first zeolite and said second zeolite.
12. The process recited in claims 1 to 11, wherein said second zeolite has a silica to alumina mole ratio of from 300:1 to 5,000:1.
- 25 13. A hydrocarbon conversion process as recited in Claim 1 comprising transalkylating an aromatic hydrocarbon by contacting under transalkylation conditions an aromatic hydrocarbon with a polyalkylaromatic hydrocarbon in the presence of a zeolite bound zeolite catalyst comprising:
30 (a) first particles of a first zeolite selected from the group consisting of large pore zeolite and medium pore zeolite having an average particle size greater than about 0.1 micron average particle size; and
35

- (b) a binder comprising second particles of a second zeolite selected from the group consisting of large pore zeolite and medium pore zeolite having an average particle size less than said first particles.

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14. The process recited in claim 13, wherein said transalkylation conditions comprise a molar ratio of aromatic hydrocarbon to polyalkylaromatic hydrocarbon of from 0.5:1 to 50:1, a temperature from 340°C to 500°C, and a pressure in the range of from 50 psig to 1,000 psig.

10

15. The process recited in claims 13 or 14, wherein said polyalkylaromatic hydrocarbon is selected from the group consisting of triethylbenzene, diethylmethylbenzene, diisopropylbenzene, triisopropylbenzene, diisopropyltoluene, dibutylbenzene, and mixtures thereof.

15

16. A hydrocarbon conversion process as recited in claim 1 comprising alkylating an aromatic hydrocarbon by contacting said aromatic hydrocarbon under alkylation conditions with a alkylating agent having 2 to 20 carbon atoms and in the presence of a zeolite bound zeolite catalyst comprising:

20

- (a) first particles of a first zeolite selected from the group consisting of large pore zeolite and medium pore zeolite having an average particle size greater than 0.1 micron average particle size; and

25

- (b) a binder comprising second particles of a second zeolite selected from the group consisting of large pore zeolite and medium pore zeolite having an average particle size less than said first particles.

30

17. The process recited in claim 16, wherein said aromatic hydrocarbon is benzene or alkylbenzenes.

35

18. The process recited in claims 16 or 17, wherein said alkylation conditions comprise a mole ratio of aromatic hydrocarbon to alkylation agent of from 1:1 to 20:1 and a reaction temperature from 10°C to 200°C.
- 5
19. A hydrocarbon conversion process as recited in claim 1 comprising isomerizing a hydrocarbon feed containing an aromatic C₈ stream comprising ethylbenzene, xylene isomers, or mixtures thereof by contacting said feed under isomerization
- 10 conversion conditions with a zeolite bound zeolite catalyst comprising:
- (a) first particles of a first zeolite selected from the group consisting of large pore zeolite and medium pore zeolite
- 15 having an average particle size greater than 0.1 micron average particle size; and,
- (b) a binder comprising second particles of a second zeolite selected from the group consisting of large pore zeolite
- 20 and medium pore zeolite having an average particle size less than said first particles.
20. A hydrocarbon conversion process as recited in claim 1 comprising cracking hydrocarbon compounds by contacting a
- 25 hydrocarbon feed under catalytic cracking conditions with a zeolite bound zeolite catalyst comprising:
- (a) first particles of a first medium pore zeolite; and
- 30 (b) a binder comprising second particles of a second medium pore zeolite having an average particle size less than said first particles.
21. The process of claim 20, wherein said hydrocarbon feed
- 35 comprises a C₄⁺ naphtha feed.

22. The process of claim 20 or 21, wherein said first particles have a particle size of from .1 to 3 microns.
- 5 23. A hydrocarbon conversion process as recited in claim 1 comprising disproportionation of toluene by contacting a hydrocarbon stream under toluene disproportionation conditions with a zeolite bound zeolite catalyst comprising:
- 10 (a) first particles of a first medium pore zeolite having an average particle size greater than about 0.1 micron average particle size; and,
- 15 (b) a binder comprising second particles of a second medium pore zeolite having an average particle size less than said first particles and a lower acidity than said first particles.
24. The process recited in claim 23, wherein said catalyst is preselectivated.
- 20 25. The process of claim 24, wherein said catalyst is preselectivated by contacting the catalyst with a toluene stream at a temperature in the range of between 480°C and 650°C at a pressure within the range of from 1 to 100 atmospheres and a weight hourly space velocity in the range of 0.1 to 20, and
- 25 wherein said toluene stream further contains hydrogen at a H₂/toluene ratio of 0 to about 2.
- 30 26. The process of claim 24 or 25, wherein said toluene disproportionation conditions include contacting said hydrocarbon stream with said catalyst at a temperature in the range of between 400°C to 550°C, at a pressure in the range of from 1 to 100 atmospheres and at a weight hourly space velocity in the range of from 0.5 to 50, and wherein said hydrocarbon stream further contains hydrogen at a H₂/toluene mole ratio in
- 35 the range of 0 to about 10.

- 5 27. The process of claims 23 to 26, wherein said second zeolite particles are MFI crystallites or crystallites which are a crystallographic match for MFI having a silica to alumina mole ratio higher than the silica to alumina mole ratio of said first phase MFI crystallites.
28. The process of claims 23 to 27, wherein said second particles have a silica to alumina mole ratio of from 300:1 to 5,000:1.
- 10 29. The process of claims 23 to 28, wherein said catalyst is in the acidic hydrogen form.
30. The process recited in claims 1 to 29, wherein said second zeolite has a silica to alumina mole ratio greater than about 300:1.
- 15 31. The process recited in claims 1 to 30, wherein said first zeolite has a silica to alumina mole ratio of from about 2:1 to about 150:1.
- 20 32. The process recited in claims 1 to 31, wherein said first zeolite and said second zeolite is a medium pore zeolite.
- 25 33. The process recited in claims 1 to 32, wherein said first zeolite and said second zeolite are selected from the group consisting of MFI, MEL, MTW, EUO, MTT, HEV, FER, TON, ZSM-34, ZSM-38, ZSM-48, gallosilicates, and titanasilicates.
- 30 34. The process of claims 1 to 33, wherein said first particles have a particle size of from 2 to 6 microns and said second particles have a particle size of from 0.1 to less than 0.5 microns.
- 35 35. The process recited in claims 1 to 34, wherein said second zeolite is a zeolite of the same type as said first zeolite or is a type which is a crystallographic match for said first zeolite.

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36. The process recited in claims 1 to 35, wherein said first particles have an average particle size of from 3 to 4 microns.
- 5 37. The process recited in claims 1 to 36, wherein said first zeolite is MFI.
38. The process recited in claims 1 to 37, wherein said second zeolite is an MFI.
- 10 39. The process recited in claims 1 to 38, wherein said second zeolite has a silica to alumina ratio of greater than about 1000:1.
40. The process recited in claims 1 to 39 wherein said zeolite bound zeolite has an Adsorption Index greater than 1.00.
- 15 41. The process recited in claims 1 to 40 wherein said second zeolite has a silica to alumina ratio that is greater than the silica to alumina ratio of said first zeolite.
- 20 42. The process recited in claims 1 to 41 wherein said zeolite bound zeolite has an Adsorption Index greater than 1.10.

Figure 1

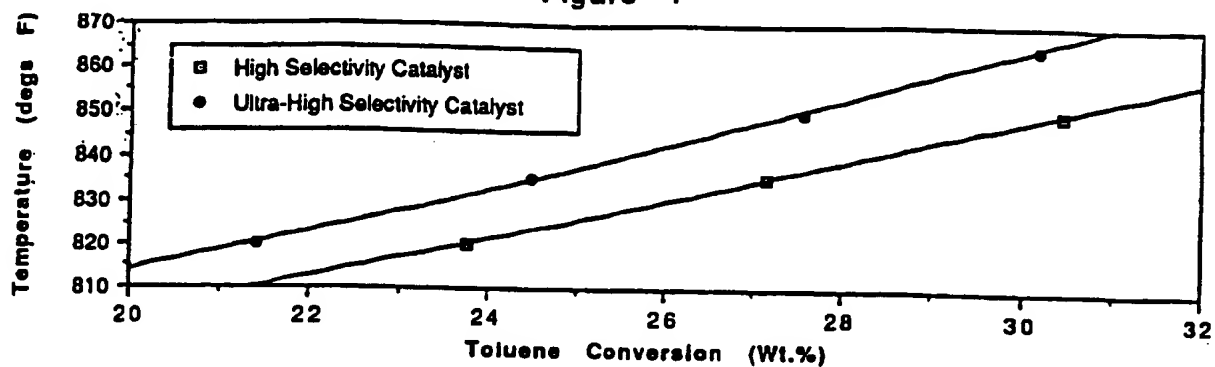


Figure 2

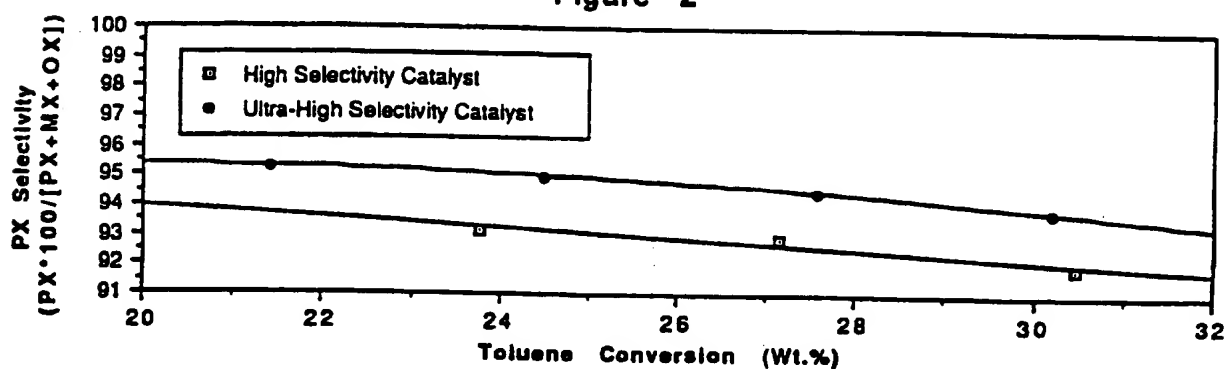


Figure 3

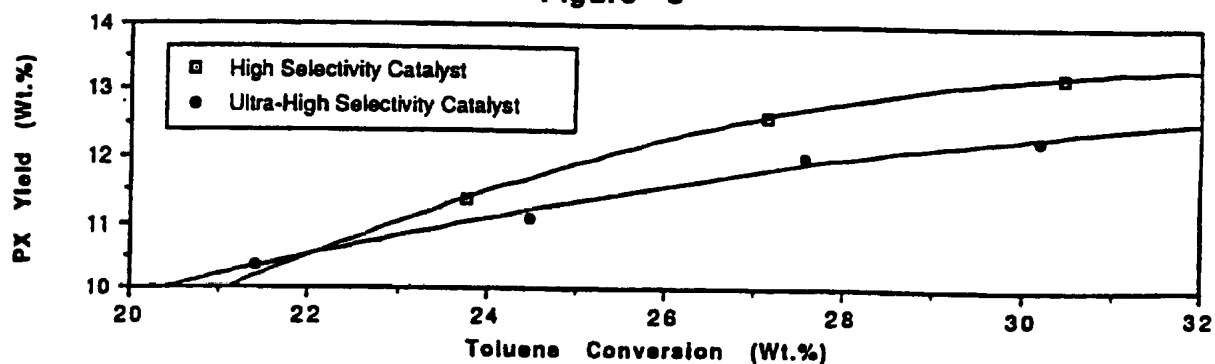
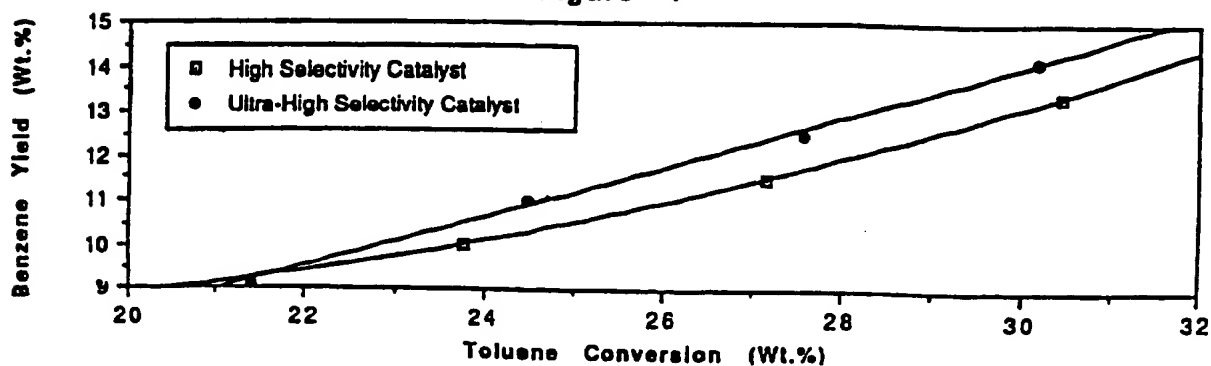


Figure 4





A DOCPHOENIX

APPL PARTS

IMIS _____
Internal Misc. Paper
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Misc. Incoming Letter

371P _____
PCT Papers in a 371 Application

A... _____
Amendment Including Elections

ABST _____
Abstract

ADS _____
Application Data Sheet

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APPENDIX _____
Appendix

ARTIFACT _____
Artifact

BIB _____
Bib Data Sheet

CLM _____
Claim

COMPUTER _____
Computer Program Listing

CRFL _____
All CRF Papers for Backfile

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IDS Including 1449

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OATH _____
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SPEC _____
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OUTGOING

CTMS _____
Misc. Office Action

1449 _____
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APDEC _____
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Examiner Answer

CTAV _____
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M903 _____
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M905 _____
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NFDR _____
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INCOMING

AP.B _____
Appeal Brief

C.AD _____
Change of Address

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File Wrapper

FWCLM _____
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CLMPTO _____
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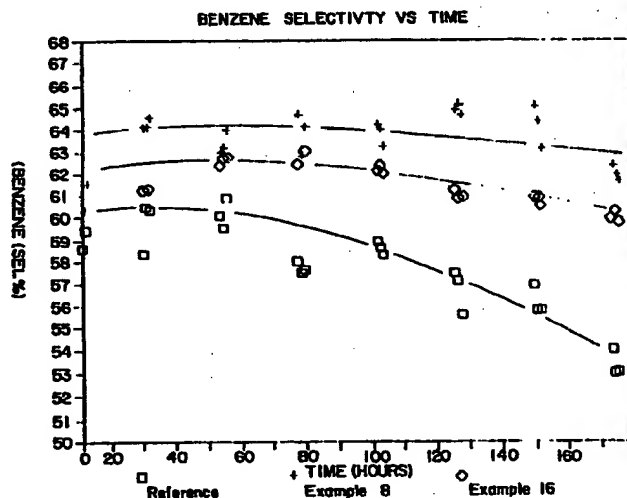
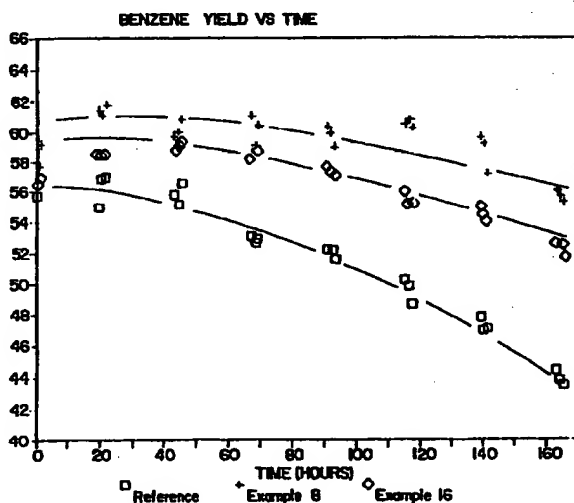
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Fee Worksheet



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(21) International Application Number: PCT/US90/06306 (22) International Filing Date: 30 October 1990 (30.10.90) (30) Priority data: 8924410.7 30 October 1989 (30.10.89) GB (71) Applicant (for all designated States except US): EXXON RESEARCH AND ENGINEERING COMPANY [US/US]; 180 Park Avenue, Florham Park, NJ 07932 (US). (72) Inventor; and (75) Inventor/Applicant (for US only): VERDUIJN, Johannes, Petrus [NL/NL]; Westersingel 34, NL-3202 XL Spijkenisse (NL). (74) Agent: SHERER, Edward, F.; Exxon Chemical Company, P.O. Box 5200, Baytown, TX 77522-5200 (US).	(81) Designated States: AT (European patent), BE (European patent), CA, CH (European patent), DE (European patent), DK (European patent), ES (European patent), FR (European patent), GB (European patent), GR (European patent), IT (European patent), JP, KR, LU (European patent), NL (European patent), SE (European patent), US. Published Without international search report and to be republished upon receipt of that report.	

(54) Title: ZEOLITE L



(57) Abstract

Potassium zeolites of type L in which the crystals are very flat cylinders of "hockeypuck" or "coin" shape may be prepared by adjusting the K_2O/SiO_2 and SiO_2/Al_2O_3 ratio and including in the mixture from which the zeolite is crystallized a small amount of divalent cation such as magnesium or barium. The resulting zeolite has a short channel length and is particularly useful as a base for aromatization catalysis.

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ZEOLITE L

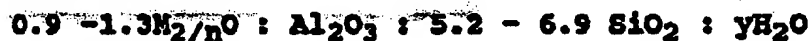
- 1 -

FIELD OF THE INVENTION

The present invention relates to a zeolite of the L type, and a process for its production. This zeolite is a
5 good catalyst base for a variety of organic reactions, especially hydrocarbon conversions, and may be regenerated after use.

BACKGROUND OF THE INVENTION

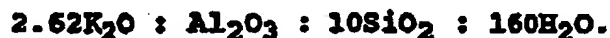
Zeolite L has been known for some time as an
10 adsorbent and in US-A-3216789 is described as an aluminosilicate of the formula:



(where M is an exchangeable cation of valency n and y is
from 0 to 9) having a characteristic X-ray diffraction
15 pattern.

EP-A-96479 describes a zeolite L which is particularly useful as a catalyst base in hydrocarbon conversions such as aromatization. The zeolite comprises crystallites in the form of cylinders with a mean diameter
20 of at least 0.1 micron, preferably at least 0.5 micron and with an aspect ratio (ratio of cylinder length to diameter) of at least 0.5. The gel from which the zeolite is obtained comprises the following ratios of components: 2.4 to 3.0 moles K_2O , 0.6 to 1.3 moles Al_2O_3 , 8 to 12 moles of SiO_2
25 and 120 to 240 moles H_2O . A particularly preferred gel has the following compositions:

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The potassium form of zeolite L, hereinafter identified as zeolite KL, may also contain caesium, as described in EP-A-323892.

5 Typically the zeolite is loaded with one or more metals such as platinum, tin, germanium, rhenium or iridium, particularly platinum, to prepare the desired catalyst.

New forms of zeolite KL are sought which are particularly useful as a catalyst base for aromatization and which permit regeneration of spent catalyst. Imperfections in the zeolite crystals and relatively long uni-directional zeolite channels result in poor utilization of Pt, poor maintenance of catalyst activity, and
15 undesirable secondary reactions. To improve the properties of such a zeolite the channel length of the zeolite should be decreased to well below one micron, but at the same time the surface area of the zeolite crystal should be maintained as large as is practicable, and the crystals
20 should be well-formed i.e. without a significant level of crystal imperfections.

These features are present if well-formed zeolite crystals can be made in the form of very flat cylinders. The present invention provides a zeolite whose crystals
25 have the requisite properties; the present invention also provides a process for producing such zeolites.

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SUMMARY OF THE INVENTION

Accordingly the present invention provides a zeolite of the KL-type in which the crystals are cylindrical and have an average length of 0.6 microns or less and an average length: diameter ratio of less than 0.5 and have substantially flat basal planes.

It is believed that in such a zeolite the flatness of the basal planes is an indication of the intrinsic quality of the crystals and the shortness of the crystal length makes for less meandering channels.

DESCRIPTION OF PREFERRED EMBODIMENTS

The cylindrical crystal particles are substantially in the form of cylinders of circular cross-section, and preferably substantially in the form of right circular cylinders where the base is normal to the cylinder axis.

The crystals are coin or hockey puck shaped and have a relatively large diameter and short length. The "length" of a crystal is a measurement of the outer edge of the crystal perpendicular to the basal plane containing the diameter. The length is typically 0.1 to 0.6 preferably 0.1 to 0.3 microns and the diameter is generally 0.3 to 1.5 microns preferably 0.4-1.0 microns. When the length/diameter ratio is 0.2-0.5 the crystal shape is termed herein as "hockey puck". When the ratio is less than 0.2 the shape is termed herein as "coin".

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The crystals thus possess the advantages of a short channel length and of a relatively large diameter which gives increased selectivity and/or yield when it is used as a base for a catalyst. The average length of time over
5 which the catalyst remains active i.e. the run length of the process before the catalyst requires regeneration is longer with the present form of zeolite than with previous zeolites I of larger channel length and crystal size. Another advantage is that crystals of the present invention
10 are easy to recover from the synthesis magma.

The crystals also have microscopically flat basal planes. This is an indication that the crystals are well-formed and have an acceptably low level of crystal imperfections. A measure of flatness is the ratio of
15 height:length, where the height is the longest measurement in the same direction as the length. Thus if the basal plane contains raised steps or terraces the maximum measurement or height of the crystal will be greater than the measurement of the length. If the basal planes are flat
20 the height:length ratio will be 1. The height:length ratio of the crystals should be as close as possible to 1, but a ratio of up to 1.2 may be tolerated.

The zeolites of the invention are preferably aluminosilicates and will be described hereinafter in terms
25 of aluminosilicates, though other elemental substitutions are possible, for example aluminium may be substituted by

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gallium, boron, iron and similar trivalent elements, and silicon may be substituted by elements such as germanium or phosphorus.

Preferably the zeolite synthesis mixture comprises
5 water, a source of divalent cation, a source of K_2O , a source of SiO_2 and a source of alumina. The divalent cation may be a cation of nickel, magnesium, calcium, barium, cobalt, manganese, zinc, copper or tin. Magnesium and barium have each been found to be particularly
10 effective when included in the synthesis mixture for the zeolite. Initial results show that cobalt-containing zeolites are comparable with magnesium or barium-containing zeolites.

The proportions of the materials in the synthesis
15 mixture may be adjusted to obtain the necessary crystal morphology. Preferably the synthesis mixture should contain sources which provide a molar ratio of K_2O/SiO_2 of 0.20 - 0.35 more preferably 0.24 - 0.30.

Preferably the mixture should contain sources which
20 provide a molar ratio of SiO_2/Al_2O_3 of 15-160, more preferably 20-40, and a molar ratio of H_2O/K_2O of 45-70, more preferably 50-65.

The ratios are, as is usual with zeolite synthesis mixtures, interdependent. For example, if a high
25 SiO_2/Al_2O_3 ratio is used, then a high K_2O/SiO_2 ratio should also be used to obtain the necessary alkalinity.

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Thus the zeolite is preferably one which is the crystallisation product of a mixture comprising q moles of water, a divalent cation, a source of m moles of K_2O , a source of n moles of SiO_2 and a source of p moles of Al_2O_3 5 where m:n is 0.2 to 0.35 and n:p is 15 to 160 and q:m is 45 to 70. More preferably m:n is 0.24-0.30, n:p is 20-40 and q:m is 50:65.

A typical ratio of the synthesis mixture is e.g. 2.65 K_2O /0.5 Al_2O_3 /10 SiO_2 /160 H_2O , and a suitable quantity 10 of divalent cation.

Increasing the proportion of alumina tends to increase the ratio of length to diameter, and also to increase the tendency for the contaminant, zeolite W, to form. Increasing the proportion of H_2O also has this 15 effect.

Increasing the proportion of SiO_2 congruently increases the dimensions of the crystals produced, and also increases the tendency for undesirable amorphous byproducts to form. Increasing the proportion of potassium increases 20 the tendency for the crystals to have rough basal planes, and hence an increase in the height/length ratio.

The inclusion of a divalent cation source in the zeolite synthesis mixture encourages the formation of flat basal planes and small crystals of low l/d ratio, and 25 reduces the formation of crystalline contaminants such as zeolite W and erionite.

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The amount of divalent cation which should be present in the synthesis mixture depends on the particular cation. However, in general up to 250 ppm based on the weight of the synthesis gel is used. Barium may be used in
5 an amount up to 250 ppm, but an advantageous effect is seen when much smaller amounts, such as 100 ppm, are used. Magnesium, on the other hand, need only be present in an amount of about 10 ppm to obtain hockey puck shaped crystals. Although a source of silica, for example, may
10 contain e.g. magnesium as an impurity it has been found that such silica does not produce the same advantageous effect as when the magnesium or other cation is added to the synthesis mixture from a separate source.

The temperature at which the gel is heated to
15 produce the zeolite also affects the morphology of the crystals produced. If the temperature is reduced then there is more nucleation, producing smaller crystals which have small channel lengths and hence are desirable. However, there is also a tendency for the crystals to have rough
20 domed basal planes so that instead of the crystals being flat cylinders they are clam-like in shape. The crystallization temperature should therefore be chosen with a view to obtaining crystals of as small a size as is reasonable whilst maintaining the desired crystal shape.
25 Typical temperatures used to obtain crystals of the desired shape are 150 to 200°C.

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Accordingly, the proportions of the synthesis ingredients substances and the crystallization temperature should be adjusted to obtain the necessary dimensions e.g. length, diameter and shape of crystals, and the proportions
5 and amounts specified above and in the examples are given for guidance.

The zeolite of type KL may be prepared by simple adaptation of techniques known in the art for producing zeolites. For example a source of silica and a source of
10 divalent cations may be mixed with an aqueous solution of an alumina source and a K_2O source, to form a gel and this gel heated to form the zeolite crystals. Typically the gel is heated at 150 to 200°C for a period long enough to form the crystals. This is generally from 60 to 172 hours,
15 typically between 60 and 160, preferably 60 to 150 hours. In general the lower the temperature the longer the time required to reach the same degree of crystallisation with the same synthesis mixture.

The source of silica may be e.g. solid silica or an
20 aqueous solution or colloid of silica such as that sold under the trade name "Ludox" available from E.I. Dupont de Nemours & Co. Colloidal Sols are preferred since they result in less contaminating phases. However other forms such as silicates may be used. The source of divalent
25 cations may be provided in the form of a powder or a

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solution, e.g. an aqueous solution of an alkaline earth metal hydroxide.

The source of alumina may be an alumina introduced into the synthesis mixture as e.g. $\text{Al}_2\text{O}_3 \cdot 3\text{H}_2\text{O}$ previously dissolved in alkali. It is also possible to introduce a source of alumina into the synthesis mixture in the form of aluminium metal dissolved in alkali.

The source of K_2O is preferably introduced into the synthesis mixture as potassium hydroxide.

10 During the production of zeolite KL, stirring the synthesis mixture during heating increases nucleation and therefore speeds up the formation of crystals and encourages the formation of smaller crystals. However, this has the disadvantage that it also encourages the formation
15 of the undesirable contaminant, zeolite W. Inclusion of a divalent metal cation according to the present invention allows the synthesis mixture to be stirred during crystallization but suppresses the formation of zeolite W.

The aluminosilicate forms of the invention may be
20 hydrated, typically with from 0 to 9 moles of water per mole of Al_2O_3 . When used as a catalyst base, the zeolite of the invention is preferably first calcined to remove water. In normal preparation from aqueous gels a hydrated form is first prepared and this may be dehydrated by heating.

25 The product of the process is predominantly a potassium form of the aluminosilicate. By ion exchange of

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the product in the manner well-known to zeolite chemistry, other cations such as Na or H can be introduced in place of the potassium.

The zeolite may be treated in the same way as
5 conventional zeolites L to improve its mechanical strength e.g. by forming an extrudate.

A catalyst based on the zeolite may be formed by impregnating or "loading" the zeolite with a metal which promotes the desired reaction e.g. aromatization. The
10 metal is preferably platinum or a mixture of platinum and at least one other metal such as tin, germanium, rhenium or iridium. The total amount of metal loaded on the zeolite is typically 0.4 to 0.8 weight % based on the weight of the zeolite, preferably about 0.6 weight %. The loading may be
15 carried out by processes known in the art.

DESCRIPTION OF THE FIGURES

Reference is made in the examples to five figures:

Figure 1A and 1B show a scanning electron micrograph (SEM) of "hockeypuck" zeolite crystals.

Figure 2A and 2B show a SEM of comparative zeolite crystals which are not of the desired shape.

Figure 3A and 3B show SEMs of "hockeypuck" zeolite crystals.

Figure 4 shows SEMs of "hockeypuck" zeolite crystals made in a large volume and a small volume synthesis.

Figure 5A and 5B show the benzene yield and selectivity for three catalysts.

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EXAMPLES

The following examples illustrate the invention:

EXAMPLE 1:

Preparation synthesis mixture (weight of reactants
5 are given in grams).

POTASSIUM ALUMINATE SOLUTION:

KOH pellets (86.8% purity) 34.30

Al (OH)₃, (98.6% purity) 7.91

H₂O 50.10

10 Rinse water 25.00

Silicate Solution:

Colloidal Silica (Ludox HS-40*) 150.26

Ba(OH)₂ 8 H₂O Crystals 0.0999

H₂O 50.01

15 Rinse water 64.47

The alumina was dissolved in the KOH solution by boiling. The solution was cooled to room temperature and corrected for weight loss.

The Ba-source was dissolved in a portion of the
20 water and was added to the Ludox together with another portion of the water which was used to rinse the beaker containing the Ba-source. The resulting solution was stirred for 5 minutes. Next the aluminate solution including the rinse water was added and the whole was mixed
25 for another 3 minutes.

* Ludox HS-40 is a colloidal Silica of DUPONT.

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The composition of the synthesis mixture was:

2.65 K₂O/0.0032 BaO/0.5 Al₂O₃/10 SiO₂/159 H₂O

This corresponds to 115 ppm Ba⁺⁺ based on the weight of the gel. 323.10 g of the synthesis mixture was
5 transferred to a 300 ml stainless steel autoclave. The autoclave was placed in an oven and heated up to 170°C and was kept at this temperature for 96 hours.

The product was separated from the mother liquor by centrifuging. It was washed to pH 9.7 and dried overnight
10 at 150°C. The weight of the recovered product was 25.1 gram.

The product was analyzed using x-ray diffraction (XRD), Scanning Electron Micrographs (SEM), and Toluene Adsorption Measurement (TGA) with the following results:

15 XRD : pure KL, crystallinity vs standard: 92%
SEM : flat crystals with microscopically flat basal planes,
Length : ~0.20 microns;
diameter : ~0.60 microns;
20 1/d ratio : ~0.3;
height/length (h/l) ratio : 1.
TGA : wt % toluene adsorption at p/po = 0.25,
T = 30°C:10.6.

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EXAMPLE 2: (Comparative):

Synthesis without added divalent cations.

An identical synthesis mixture was prepared as in example 1, but in this case no Ba was added to the synthesis mixture used. The synthesis mixture was crystallized for 96 hours at 170°C. The product was analyzed by XRD and SEM with the following results:

10 XRD : the product was partially crystalline, e.g. contained amorphous gel particles and was contaminated with an Erionite-like crystalline phase.

Crystallinity vs standard : 45%.

15 SEM : micrographs showed the presence of amorphous gel particles and other contaminants. The KL crystal had a low l/d ratio but the crystals were relatively large and the basal planes showed terraces and step growth. The crystallite dimensions were:

20 Length : ~1.5 microns;
diameter : ~4.5 microns;
 l/d ratio : ~0.3.

From these results can be seen that this experiment did not produce the KL-product of the invention.

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EXAMPLE 3:

Variation in the source of divalent cation.

An identical synthesis mixture was prepared as in example 1 but in this case the synthesis mixture was seeded with 9 ppm Mg^{2+} (based on the weight of the synthesis mixture). The Mg^{2+} source was $Mg(NO_3)_2 \cdot 6 H_2O$. The synthesis mixture was crystallized at $170^\circ C$ for 96 hours. The resulting product was analyzed by XRD, SEM and TGA with the following results.

- 10 XRD : pure KL, crystallinity vs standard: 97%
- SEM : flat KL crystals with microscopically flat basal planes,
- Length : 0.1 - 0.4 microns;
- diameter : 0.4 - 0.8 microns;
- 15 l/d ratio : ~0.4;
- height/length (h/l) ratio : 1.
- TGA : wt % toluene adsorption: 10.5.

Examples 4 and 5: variation in the K_2O content of the synthesis mixture.

20 **EXAMPLE 4: (Comparative):**

This shows the effect of increased K_2O level in the synthesis mixture. A synthesis mixture was prepared in the same way as in Example 1 but with a molar composition of:

3.00 K_2O /0.0064 BaO/0.50 Al_2O_3 /10 SiO_2 /160 H_2O

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This mixture was crystallized for 72 hours at 170°C. The resulting product was analyzed by XRD, SEM and TGA with the following results:

- XRD : pure KL, crystallinity vs standard: 76%
- 5 SEM : flat KL crystals with terraces on the basal planes,
Length : ~0.15 microns;
diameter : ~0.15 - 0.3 microns;
l/d ratio : ~0.4;
10 height/length (h/l) ratio : >1.
- TGA : wt % toluene adsorption: 11.0.

This did not give the crystals of the invention since the basal planes were not sufficiently flat.

EXAMPLE 5:

- 15 A synthesis mixture was prepared in the same way as in Example 1 but with a molar composition of:

2.40 K₂O/0.0064 BaO/0.50 Al₂O₃/10 SiO₂/159 H₂O

i.e. reducing the alkalinity to the region of its lowest limit.

- 20 The mixture was crystallized for 96 hours and for 144 hours at 170°C. The product obtained after 96 hours had a low XRD-crystallinity (53% vs standard) and contained amorphous gel particles. The product after 144 hours crystallization still had a low XRD crystallinity (67% vs
25 standard) and was slightly contaminated with an Erionite-like crystalline phase. The 144 hours - product consisted

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of flat KL crystals with microscopically flat basal planes.
The particle size distribution was significantly increased.

Crystallite dimensions:

Length : 0.2 - 0.8 microns
5 Diameter : 0.3 - 1.0 microns
1/d ratio : 0.2 - 0.6.

Further examples were carried out in which various parameters were varied in the compositions and their preparations. Table 1 gives details of the synthesis of the
10 various zeolites and Table 2 gives details of the characteristics of the resulting products. Examples 1, 3, 5, 8, 9, 11 to 13 and 15 illustrate the invention.

TABLE 1
SYNTHESIS CHARACTERISTICS

Example	Parameter varied	Composition					Synthesis Mixture		Crystallization		
		K ₂ O	Al ₂ O ₃	SiO ₂	H ₂ O	divalent cations type	wt ppm	conc	time hrs	t ₉₀ °C	
6	Reference synthesis	3.40	0.50	10	160	-	-	-	45	150	
2	Alkalinity, temp, time	2.65	0.50	10	160	-	-	-	96	170	
7	time	2.65	0.50	10	160	-	-	-	144	170	
4	N ²⁺ added, alkalinity increased	3.00	0.50	10	160	Ba ²⁺	230	230	72	170	
8	N ²⁺ added, alkalinity reduced	2.65	0.50	10	160	Ba ²⁺	230	230	72	170	
1	N ²⁺ reduced, time	2.65	0.50	10	160	Ba ²⁺	115	115	96	170	
5	alkalinity reduced	2.40	0.50	10	160	Ba ²⁺	230	230	96	170	
5	time increased	2.40	0.50	10	160	Ba ²⁺	230	230	144	170	
3	variation N ²⁺ type	2.65	0.50	10	160	Mg ²⁺	9	9	96	170	
9	Al ₂ O ₃ reduced	3.00	0.25	10	160	Ba ²⁺	230	230	72	170	
10	Al ₂ O ₃ reduced, no N ²⁺ added	3.14	0.176	20	159	-	-	-	78	150	
11	N ²⁺ added	3.14	0.176	10	159	Ba ²⁺	228	228	78	150	
12	Al ₂ O ₃ reduced	3.14	0.125	10	159	Ba ²⁺	228	228	118	150	
13	Al ₂ O ₃ further reduced	3.14	0.100	10	159	Ba ²⁺	228	228	118	150	
14	Al ₂ O ₃ still further reduced	3.14	0.063	10	159	Ba ²⁺	228	228	118	150	
15	Alkalinity adjusted	3.38	0.063	10	159	Ba ²⁺	226	226	118	150	

TABLE 2
PRODUCT CHARACTERISTICS

Example	Parameter varied	XRD		TGA		SEM			
		cryst. contaminants (a)	toluene adsorption (b)	L (microns)	H (microns)	Crystallite			
						D	l/d ratio	n/l ratio	morph. c
6	Refetcher synthesis	-	-	-0.1	-0.25	-0.7	-0.15	2.5	tc
2	Alkalinity, temp, time	45 amorphous	-	-1.5	-2.5	-4.5	-0.4	1.7	c/l
7	Time	72 ERI/OPF	-	-1.5	-2.5	-4.5	-0.4	1.7	c/l
4	N ²⁺ added, alkalinity	76 none	11.1	-0.15	spiral steps	-0.25	-0.3	>1	hp
8	N ²⁺ added, alkalinity reduced								
1	N ²⁺ reduced, time	89 none	10.0	-0.15	-0.15	-0.40	-0.4	1	hp
5	alkalinity reduced	92 none	-	-0.20	-0.20	-0.60	-0.3	1	hp
5	time increased	53 amorphous	-	0.2-0.8	0.2-0.8	0.3-1.0	-0.3	1	bp
3	variation N ²⁺ type	67 traces ERI/OPF	-	0.2-0.8	0.2-0.8	0.3-1.0	-0.3	1	hp
9	Al ₂ O ₃ reduced	97 none	10.5	0.1-0.4	0.1-0.4	0.4-0.8	-0.4	1	hp
10	Al ₂ O ₃ reduced, no N ²⁺ added	85 none	10.8	0.1-0.2	0.1-0.2	0.3-1.0	-0.2	1	bp
11	N ²⁺ added	<5 amorphous	-	-	-	-	-	-	-
12	Al ₂ O ₃ reduced	74 none	11.2	0.05-0.1	0.05-0.1	0.4-0.9	-0.1	1	c
13	Al ₂ O ₃ further reduced	77 none	-	0.05-0.1	0.05-0.1	0.6-1.4	<0.1	1	c
14	Al ₂ O ₃ still further reduced	35 amorphous	1.9	0.07-0.1	0.07-0.1	0.8-1.3	<0.1	1	c
15	Alkalinity adjusted	<5 amorphous	-	-	-	-	-	-	-
		77 w/1-0.20	8.9	-0.1	-0.1	0.8	-0.1	1	c

(a)

(b)

(c)

= a crystallinity vs. standard
 ERI = erionite contaminant
 OPF = offretite contaminant
 N²⁺ = N₂ gas, T = 30°C

= flat glass
 = glass-like
 = Rochepack
 = Coils

= tc
 c/l
 hp
 c

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Figure 1A shows scanning electron micrographs of the crystals of zeolite prepared in Example 1 (using Ba^{2+} as the cation). Figure 1B shows scanning electron micrographs of crystals of zeolite prepared in Example 3 (using Mg^{2+} as the cation). The magnification of Figures 1A and 1B is 40000 times.

Figure 2A and 1B scanning electron micrographs of the crystals of zeolite prepared in Example 2 in which no divalent cation was used. The magnification of Figure 2A is 10000 times. The magnification of Figure 2B is 40000 times. A comparison of Figure 2A and 2B with Figure 1A and 1B shows that the crystals of Example 2 are much larger and do not have flat basal planes.

The wavy lines in the right half of Figure 2A and 2B show the contamination by amorphous particles of unreacted gel.

Figure 3A shows scanning electron micrographs of the crystals of zeolite prepared in Example 4. Figure 3B shows scanning electron micrographs of the crystal of zeolite prepared in Example 5. It can be seen that the crystals of Example 4, in which the K2O content is increased, are not flat and have terraces on the basal planes. The magnification of Figures 3A and 3B is 40000 times.

Examples 16:

This example illustrates the use of Mg^{2+} as the divalent cation, and demonstrates that the slower heating up of a gel which would be a feature of large scale production can be used successfully to produce crystals of the desired shape and dimensions.

25 litres synthesis. Preparation synthesis mixture (weight of 25 reactants given in grams):

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5	(A)	KOH	(87.7% purity)	1878.06
		Al(OH) ₃	(99.3% purity)	433.07
		H ₂ O		3154±5
		Rinse Water		420.0
	(B)	Ludox HS-40		8250±5
		Mg(NO ₃) ₂ ·6H ₂ O		2.0484
		H ₂ O		1799.67
		H ₂ O		4640±5
		Rinse Water		420.0

10 SOLUTION A:

The ingredients were dissolved with boiling water under reflux in a 6 litre pyrex bottle and the solution cooled to room temperature.

SOLUTION B:

15 The Mg²⁺ source was dissolved in 1799.67 grams of the water. In a separate 25 litre polypropylene flask the Ludox was diluted with 4640 grams of water and this solution was poured into the autoclave. The polypropylene flask was rinsed with 420 grams of water and the rinse
20 water added to the autoclave. The Mg²⁺ solution was then poured into the diluted Ludox solution in the autoclave and the whole was mixed for 5 minutes.

Solution A was then added and mixing was continued for a further five minutes. A thick, smooth gel was
25 obtained.

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The gel composition was:

2.67 K₂O/0.50 Al₂O₃/10 SiO₂/160 H₂O + 9 ppm Mg²⁺

The gel was heated up over 10 hours to 170°C although it took approximately 13 hours for the centre of the autoclave to reach 170°C. The autoclave was maintained at 170°C for 93 hours.

Before heating the gel a small sample (123.77 grams) of the gel was removed and crystallized separately as a satellite batch in an oven.

10 After crystallization a sample was taken from the main batch, washed to pH10.2 and the product was dried for 6 hours at 126°C and 16 hours at 150°C. The weight of product recovered was 200 grams.

Samples from the main and satellite batches were 15 analysed. X-ray diffraction showed the crystallization of the main batch to be 95% compared with the standard, and the crystallization of the satellite sample to be 96% compared to the standard.

Both products were very slightly contaminated with 20 erionite.

Figure 4(A), 4(B), 4(C) and 4(D) show the scanning electron micrographs of the crystals of zeolite prepared according to this example. Figures 4A and 4B are the satellite batch. Figures 4C and 4D are the batch crystallized in the 25 litre autoclave. Figure 4A and 4C 25 are at magnification 20000 times, and Figure 4B and 4D are at magnification